

Date: Tuesday, 1/23/2007 7:31:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 30376		
Estimate Number	: 10101		
P.O. Number	: <i>N/A</i>	Part Number	: D2011101
This Issue	: 1/23/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2011 REV. F
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 29773	Drawing Revision	: F
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 1/29/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	50 Um: Each
Comment	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2929 C207101124* (50)
 Purchase Grote Mirror P/N: 28043
 Possible supplier: UAP/NAPA
 Material release note required

2.0	28043	MIRROR 6"
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	D30141	Locknut
-----	--------	---------


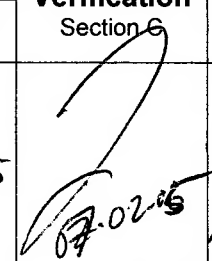

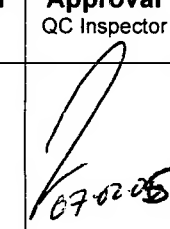


Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Locknut
 Pick:
 Qty Part Number Description Batch
 1 D3014-1 Lock nut *m18605*

MF 07-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/05	7	1 minor broke when hole were drill	 QS1012	Scrap & destroy	SB 07/02/05	 07-02-05	 QS1012	 07-02-05

NOTE: Date & initial all entries

Date: Tuesday, 1/23/2007 7:31:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 30376

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

m101237

MF 07-02-02

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

MF 07-02-02

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

MF 07-02-02

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch
9ml N/A Sikaflex-291/-241

m100672

MF 07-02-02

Expiry date

08/07

Start: 1:05 Time: 1:05

Finish: 07/02/02 Time: 7:30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

SP 07/02/05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5199

07/02/05 49

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/06

Job Completion



07/02/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

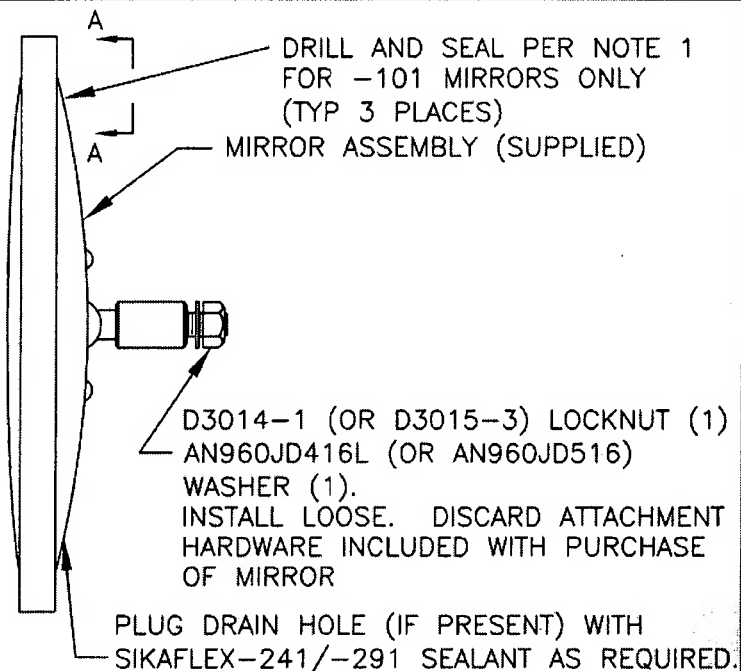
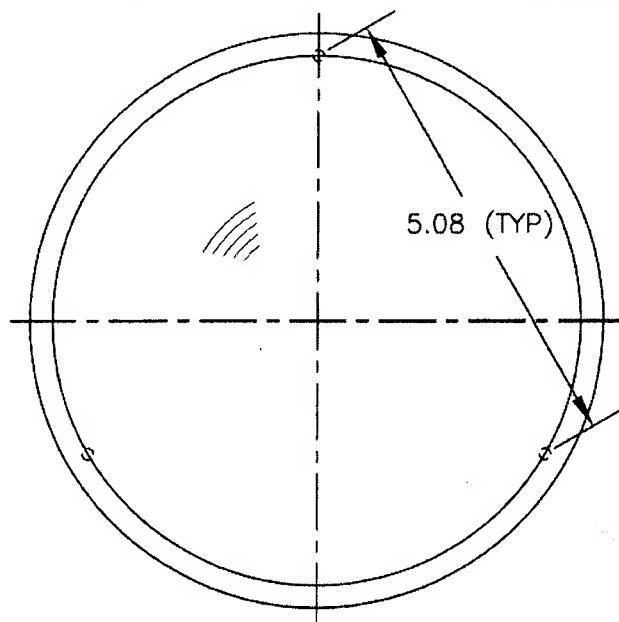
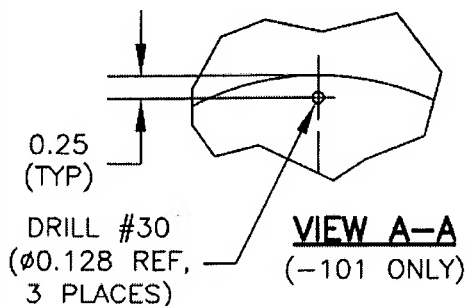
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10		TITLE MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	

**RELEASED**
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

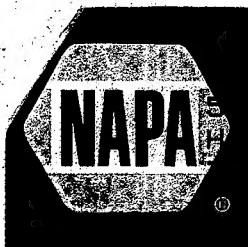
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30376

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



HAWKESBURY AUTO PARTS INC 5580GST#: 861597896RT0001
4 MAIN STREET WEST EXC#:SU 6259 EXP:03/12/31
HAWKESBURY, ONT. K6A 2J2
L:632-8575 FAX: 632-1539
DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	1/29/07	14:20	060004074	31	148348
SR #		PURCHASE ORDER #				ATTENTION
E		6122-5207				
AD		TAX EXEMPTION:				
E4		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				

PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043	GRU	GRUTE	50.00	41.140	16.820	841.00

REFUNDED BY _____

Subtotal 841.00
Tax 6% GST ONLY 50.46
Tax 0% 0.00

VERIFIED BY _____

Emile Baucher
SIGNATURE

TOTAL -----> CHARGE SALE 891.46

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

Comments:		Tax Summary:		Less:			
		GST	50.46	included tax		0.00	
		GSTME	0.00	Subtotal		841.00	
		GSTND	0.00	Total tax		50.46	
Entered By: <i>CL</i> CLAVOIE		Approved By: _____		Total purchase order in			
				CAD Dollars		891.46	